

Date: Thursday, 2/22/2007 3:03:01 PM  
 User: Kim Johnston

## Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : SHORT STEP ASSEMBLY LOW SKID LH  
 Job Number : 30844  
 Estimate Number : 12365  
 P.O. Number : *N/A* Part Number : D350591215  
 This Issue : 2/22/2007 S.O. No. : *N/A* Drawing Number : D3168 REV A  
 Prsht Rev. : NC Project Number : N/A  
 First Issue : *N/A* Type : LARGE FAB ASSY Drawing Revision : A  
 Previous Run : 26681 Material : *N/A*  
 Written By : Due Date : 3/19/2007 Qty: 3 Um: Each  
 Checked & Approved By : *07.02.23*  
 Comment : Est Rev: A 02.10.17 New issue KJ/RF  
 Est Rev: B 06-06-19 Added D2732-030 AS PER DSI9294  
 JLM  
 Est Rev: C 06-06-27 Revised as per DSI9340 JLM

## Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 DC DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Photocopy bluefile and type labels as per PPP D350-591-215 CHG002

*KS 07.03.01*

2.0 D2622120C Extrusion



Comment: Qty.: 0.5000 Each(s)/Unit Total : 1.5000 Each(s)

EXTRUSION

Batch

*B 29607**FF 07-02-28 3*

3.0 LARGE FAB 1 LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Cut D2622-120C extrusion to 57.090" long as per Dwg D3168

2-Drill extrusion as per Dwg D3168 using Jig DT8680 for rivets.(Use only 1st 6holes)

3-Deburr

*FF 07-02-28 3**KE 07-03-05 3**KE 07-03-05 3*

4.0 QC5 INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

*07/03/05 (3)*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

D30671

End Plate



Comment: Qty.: 1.0000 Each(s)/Unit Total : 3.0000 Each(s)

END PLATE

Batch

B 30143

*PE. 07-03-05*

3

6.0

D31691

Support



Comment: Qty.: 1.0000 Each(s)/Unit Total : 3.0000 Each(s)

SUPPORT

Batch

B 25200

*PE. 07-03-05*

3

7.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Bevel end for welding FWD ONLY

*DT8780*

2-Weld Support using Jig DT8781, weld Fwd End Plate as per QSI 004 & Dwg D3168

A/R Aluminum Rod

*2780*

*M100237*

*M102225*

3-Grind End Plate flush

*PE. 07-03-05*

*PE. 07-03-05*

*PE. 07-03-08*

3

3

3

8.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

*07/03/09 (3)*

9.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

*07/03/09 (3)*

10.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

*MJ / m.h 07-03-19 (3)*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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Job Number: 30844

Part Number: D350591215

Job Number:



Seq. #:

Machine Or Operation:

Description :

11.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

*Pl. 07.03.20*

3

12.0

D30771

Step Leg



Comment: Qty.: 2.0000 Each(s)/Unit Total : 6.0000 Each(s)

STEP LEG

Batch

*326684*

*Pl. 07.03.20*

3

13.0

D31701

Spacer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 6.0000 Each(s)

SPACER

Batch

*326686*

*Pl. 07.03.20*

3

14.0

MS20600AD4W4

Rivets



Comment: Qty.: 12.0000 Each(s)/Unit Total : 36.0000 Each(s)

RIVET

Batch

*M102850*

*Pl. 07.03.20*

3

15.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

Rivet Leg Assembly as per Dwg D3168

*Pl. 07.03.20*

3

16.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

*Pl. 07/03/20 (3)*

17.0

D30671

End Plate



Comment: Qty.: 1.0000 Each(s)/Unit Total : 3.0000 Each(s)

END PLATE

Batch

*330143*

*Pl. 07.03.20*

3

18.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Bevel Aft end for welding

*Pl. 07.03.20*

3

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Job Number: 30844

Part Number: D350591215

Job Number:



Seq. #:

Machine Or Operation:

Description :

2-Inspect for foreign object as per QSI 024

3-Weld Aft End Plate as per QSI 004 & Dwg D3168

A/R Aluminum Rod M100237

4-Grind End Plate flush

*Handwritten:* 07.03.20 3  
07.03.20 3  
07.03.20 3

19.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

*Handwritten:* 07/03/20 (3)

20.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

*Handwritten:* 07/03/20 (3)

21.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1  
Touch Up Chemical conversion

*Handwritten:* MS / m-h

*Handwritten:* 07-03-21 (3)

22.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

*Handwritten:* M103 706

*Handwritten:* m-h

*Handwritten:* 07/03/21

*Handwritten:* (3x)

23.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1  
Wing Walk as per Dwg D3168 and QSI 005 4.4

*Handwritten:* FR / a.m

*Handwritten:* 07/03/21 (3)

24.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: Inspect Powder Coat and Wing Walk

*Handwritten:* 07/03/22 (3)

25.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Pick Packing Kit

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Job Number:



Seq. #:

Machine Or Operation:

Description :

26.0

D2732

Rubber Extrusion



Comment: Qty.: 0.5000 f(s)/Unit Total : 1.5000 f(s)

Rubber Extrusion

2 X 3"

Batch: B26472 ✓

27.0

D2182B

Neoprene Cushion-.750 bl



Comment: Qty.: 0.3000 f(s)/Unit Total : 0.9000 f(s)

RUBBER CUSHION

2 D2182B035

Rubber Cushion Batch

B30397 -

28.0

D2274

Radius Block



Comment: Qty.: 4.0000 Each(s)/Unit Total : 12.0000 Each(s)

RADIUS BLOCK

Batch

B30518 ✓

29.0

D2856400

Abrasion Strip



Comment: Qty.: 0.6000 f(s)/Unit Total : 1.8000 f(s)

ABRASION STRIP

1 D2856-400 (7.2") Abrasion Strip Batch

B29850 ✓

30.0

D22301

Mounting Lug



Comment: Qty.: 2.0000 Each(s)/Unit Total : 6.0000 Each(s)

CLAMP

Batch

B30155 ✓

31.0

D22303

Mounting Lug



Comment: Qty.: 2.0000 Each(s)/Unit Total : 6.0000 Each(s)

CLAMP

Batch

B30273 ✓

*CP 04/23/23 ③*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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Job Number: 30844

Part Number: D350591215

Job Number:



Seq. #:

Machine Or Operation:

Description :

32.0

AN335A

Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total : 6.0000 Each(s)

BOLT

Batch

M1102339 ✓

33.0

AN411A

Bolt



Comment: Qty.: 6.0000 Each(s)/Unit Total : 18.0000 Each(s)

BOLT

Batch

M110743 ✓

34.0

AN960JD10

Washer



Comment: Qty.: 4.0000 Each(s)/Unit Total : 12.0000 Each(s)

WASHER

Batch

M108641 ✓

35.0

AN960JD416

Washer



Comment: Qty.: 12.0000 Each(s)/Unit Total : 36.0000 Each(s)

WASHER

Batch

M103338 ✓

36.0

MS21042L3

Nut



Comment: Qty.: 2.0000 Each(s)/Unit Total : 6.0000 Each(s)

NUT

Batch

M102658 ✓

37.0

MS21042L4

Nut



Comment: Qty.: 6.0000 Each(s)/Unit Total : 18.0000 Each(s)

NUT

Batch

M103349 ✓

38.0

AN413A

Bolt



Comment: Qty.: 4.0000 Each(s)/Unit Total : 12.0000 Each(s)

Bolt

Batch

M103363 ✓

*For 103/23 ③*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQA: ☒ ☐ Date: 07/03/26

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Job Number: 30844

Part Number: D350591215

Job Number:



Seq. #:

Machine Or Operation:

Description :

39.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



U 07-03-23

Comment: INSPECT 100% KITS FOR COMPLETENESS

2/27/23 (3)

40.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D350-591-215

Location:

PPP Rev:

B

2/27/23 (3)

SP

41.0

QC21

FINAL INSPECTION/W/O RELEASE



(3)

Comment: FINAL INSPECTION/W/O RELEASE

2/27/23 106

Job Completion



U 07-03-26

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



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CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. <b>D3168</b>	REV. A SHEET 1 OF 2
DATE <b>02.09.11</b>		TITLE <b>STEP ASSEMBLY, LOW SHORT</b> SCALE NTS	
A	02.09.11	NEW ISSUE	

RELEASED  
02.09.20 *[Signature]*

Part No.	Description	QTY -041	QTY -042
D3168-041	Step Assembly, Low Short (LH)	X	
D3168-042	Step Assembly, Low Short (RH)		X
D2622-60	STEP EXTRUSION	1	1
D3067-1	END PLATE	2	2
D3077-1	STEP LEG	2	2
D3169-1	SUPPORT	1	1
D3170-1	SPACER	2	2
MS20600AD4W4	RIVET	12	12

**GENERAL NOTES:**

- 1) -041 SHOWN, FOR -042 INSTALL D3169-1 SUPPORT OPPOSITE SIDE
- 2) WELD PER DART QSI 004
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.3  
BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.

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WORK ORDER  
NO. **30844**

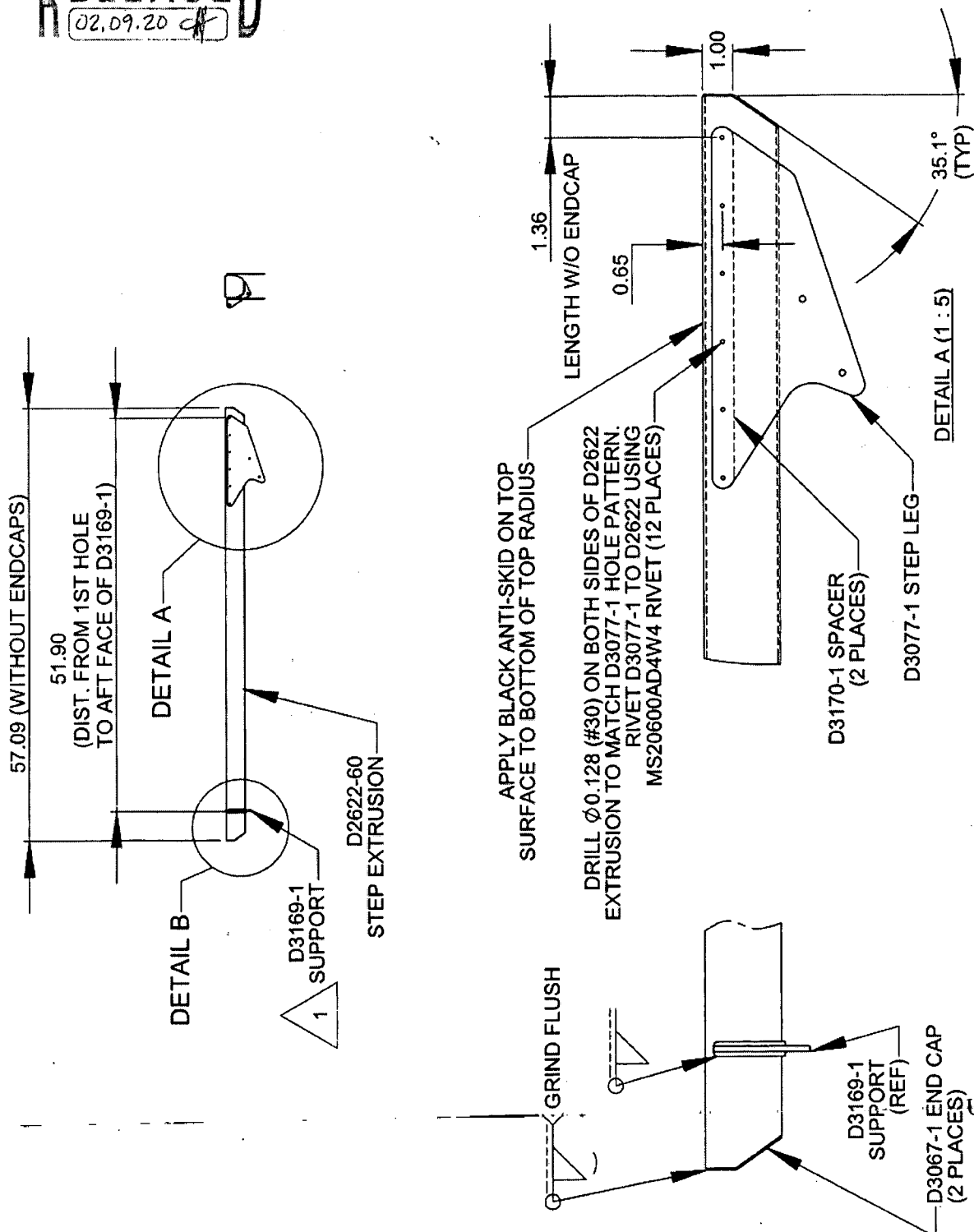
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CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. D3168	REV. A SHEET 2 OF 2
DATE 02.09.11		TITLE STEP ASSEMBLY, LOW SHORT	
		SCALE 1:20	

RELEASED  
02.09.20



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